

APPLICATION
FOR
UNITED STATES LETTERS PATENT

TITLE: PROCESS FOR PREPARING POLY(ARYLENE ETHERS)
WITH PENDANT CROSSLINKABLE GROUPS

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PROCESS FOR PREPARING POLY(ARYLENE ETHERS) WITH PENDANT CROSSLINKABLE GROUPS

STATEMENT OF RELATED CASES

This application is related to the following co-pending, concurrently filed, commonly assigned U.S. patent applications, each of which is incorporated by reference: (1) U.S.S.N. _____ entitled "Poly(arylene ethers) with Pendant Crosslinkable Groups, and Devices Incorporating Same;" (2) U.S.S.N. _____ entitled "Crosslinked Compositions Comprising a Poly(arylene ether) and a Nonlinear Optical Chromophore, and Devices Incorporating Same;" (3) U.S.S.N. _____ entitled "Process for Preparing Crosslinked Polymer Blends That Include a Luminescent Polymer;" and (4) "Crosslinked Polymer Blends That Include a Luminescent Polymer, and Devices Incorporating Same."

BACKGROUND

All patents, patent applications, and publications cited within this application are incorporated herein by reference to the same extent as if each individual patent, patent application or publication was specifically and individually incorporated by reference.

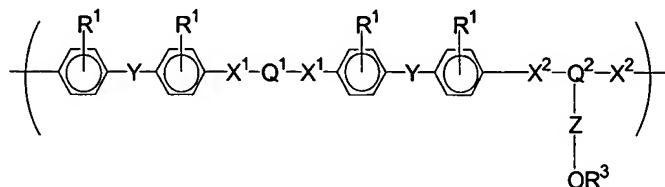
The invention relates generally to crosslinkable polymer compositions, methods of making crosslinkable polymers, and devices and uses for crosslinkable polymers. Crosslinked polymer compositions generally have higher glass transition temperatures (T_g) and greater mechanical stability than noncrosslinked polymers. In addition, crosslinked polymers are usually resistant to solvents that dissolve noncrosslinked polymers. The property of solvent resistance is particularly important in applications that require overcoating of polymers with other polymers. The properties of crosslinked polymers including high mechanical strength, high T_g , and solvent resistance are important in applications such as protective coatings, electronics, optics, electro-optics, and polymer light emitting diodes.

Poly(arylene ether)s having hydroxy, cyclopentadienone, acrylate, and alkynyl crosslinkable groups in the main chain and/or side-chain (pendant) are known, for example see U.S. Pat. No. 6,340,528; 6,313,185; 6,117,967; 6,060,170; 5,994,425; 5,849,809; 5,498,803; and 5,204,416. In some cases, functional groups have been grafted onto poly(arylene ether)s under conditions requiring long reaction times. In other cases, functional groups on the poly(arylene ether) backbone were converted into other functional groups under reaction conditions such as

reduction or lithiation/carbonyl addition, which may limit the possible monomers or pendant groups to structures that are not reactive under those conditions.

SUMMARY

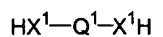
One embodiment is a polymer comprising units having the formula (I)



(I)

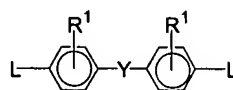
wherein: Q¹ comprises at least one aryl or heteroaryl group; Q² comprises at least one aryl or heteroaryl group; X¹ is O bonded directly to an aryl carbon of Q¹; X² is O bonded directly to an aryl carbon of Q²; Z is a linker comprising at least one $\text{---}(\text{C}(\text{R}^2)_2)\text{---}$ group; Y is a single bond or linker group (e.g., comprising up to about 50 carbons); R¹ is independently at each occurrence H, a halogen, an alkyl group, a heteroalkyl group, an aryl group, or a heteroaryl group; R² is independently at each occurrence H, an alkyl group, or a heteroalkyl group; and R³ is H or a crosslinkable group. The crosslinkable group may be chosen from any crosslinkable groups that are activated chemically, thermally, or photochemically.

Another embodiment is a process comprising: a) reacting a diphenol monomer A with a monomer B having two locations for reaction with A to form arylene ether monomer C and b) reacting arylene ether monomer C with a diphenol monomer D to form a polymer, where monomer A is



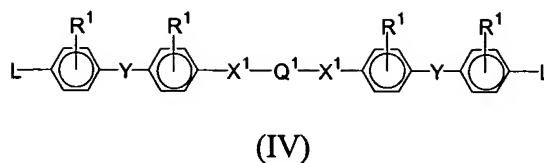
(II) ;

monomer B is



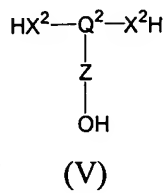
(III) ;

arylene ether monomer C is



;

and monomer D is

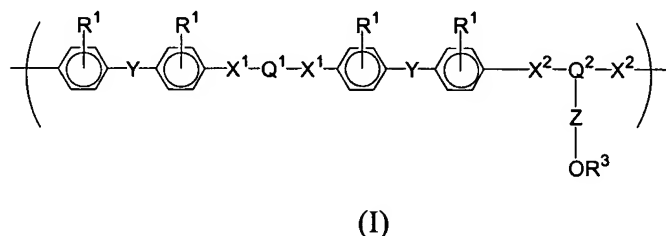


;

wherein Q^1 , Q^2 , X^1 , X^2 , Z , Y , R^1 , and R^2 are as described above and L is a leaving group.

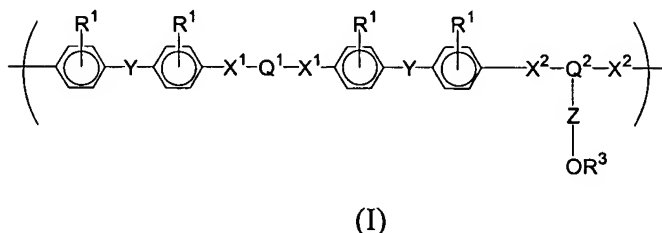
5 The process provides polymers of structure (I) that are highly regular and free of blockiness.

Another embodiment is a composition made by a process comprising a) providing a precursor composition comprising a polymer of structure (I)



10 and b) crosslinking the polymer, wherein Q^1 , Q^2 , X^1 , X^2 , Z , Y , R^1 , R^2 , and R^3 are as described above. Crosslinking may be accomplished by reaction of an R^3 crosslinking group with another R^3 crosslinking group or with additives that react with the R^3 groups. Other embodiments are optical devices comprising these compositions.

15 Another embodiment is a composition made by a process comprising a) providing a precursor composition comprising a nonlinear optical chromophore having the structure D- π -A and polymer of structure (I)



and b) crosslinking the polymer, wherein: D is a donor, π is a p-bridge, A is an acceptor, and Q^1 , Q^2 , X^1 , X^2 , Z , Y , R^1 , R^2 , and are as described above. Preferably, the process further comprises applying an electric field to effect poling. The electric field may be applied using

contact poling or corona poling. The poling may begin before crosslinking, during crosslinking, or after crosslinking. Other embodiments are electro-optic devices made from the compositions.

Another embodiment is a process comprising a) providing a polymer blend comprising a luminescent polymer and a second polymer, where at least one of the polymers is crosslinkable, and b) crosslinking the crosslinkable polymer. As used herein, a "polymer blend" is a macroscopically homogeneous mixture of two or more different species of polymer, as recited in Jenkins, A.D. et al., IUPAC Glossary of Basic Terms in Polymer Science, *Pure Appl. Chem.* 1996, 68(12), 2287-2311. In some embodiments, both polymers are crosslinkable. Other embodiments are polymer blends comprising a luminescent polymer and a second polymer, where at least one of the polymers is crosslinked. Additional embodiments include light emitting devices comprising the crosslinked compositions.

The details of one or more embodiments of the invention are set forth in the accompanying drawings and the description below. Other features, objects, and advantages of the invention will be apparent from the description and drawings, and from the claims.

DESCRIPTION OF DRAWINGS

Figure 1 illustrates a general scheme for preparing poly(arylene ether)s.

Figure 2 illustrates a process for preparing functionalized arylene ethers.

Figure 3 illustrates exemplary donors for nonlinear optical chromophores.

Figure 4 illustrates exemplary acceptors for nonlinear optical chromophores.

Figure 5-6 outline the synthesis of a crosslinkable poly(arylene ether).

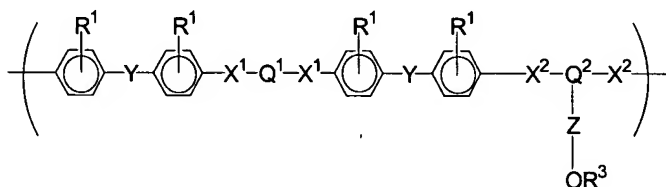
Figure 7 illustrates useful polymers and chromophores.

Figure 8 is a graph comparing electroluminescent performance.

Like reference symbols in the various drawings indicate like elements.

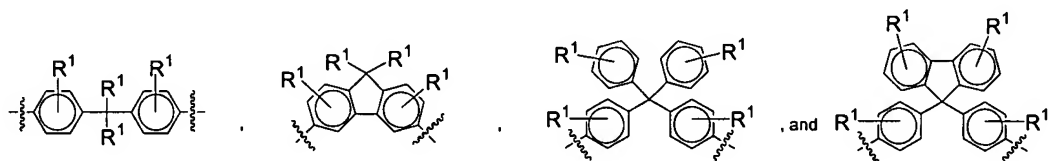
DETAILED DESCRIPTION

In one embodiment, a poly(arylene ether) polymer comprises units having the formula (I)



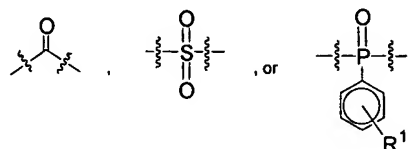
(I)

wherein: Q^1 comprises at least one aryl or heteroaryl group; Q^2 comprises at least one aryl or heteroaryl group; X^1 is O bonded directly to an aryl carbon of Q^1 ; X^2 is O bonded directly to an aryl carbon of Q^2 ; Z is a linker comprising at least one $-(C(R^2)_2)-$ group; Y is a single bond or linker group (e.g., comprising up to about 50 carbons); R^1 is independently at each occurrence H, a halogen, an alkyl group, a heteroalkyl group, an aryl group, or a heteroaryl group; R^2 is independently at each occurrence H, an alkyl group, or a heteroalkyl group; and R^3 is H or a crosslinkable group. In some embodiments, Q^1 comprises a polycyclic aromatic ring system or a polycyclic heteroaromatic ring system. In many embodiments, Q^1 comprises at least two aryl or heteroaryl groups. Preferably, the linker between the first aryl or heteroaryl group and the second aryl or heteroaryl group is a methylenediphenyl group in which the methylene carbon is bonded to at least two phenyl groups. Typically, the methylenediphenyl group originates from a bisphenol monomer. Bisphenols are compounds made by condensing one equivalent of an aldehyde or ketone with two equivalents of a phenol. Consequently, both the phenyl and methylene moiety of the methylenediphenyl group can be substituted with a variety of heteroatoms, alkyl groups, heteroalkyl groups, aryl groups, or heteroaryl groups. When structurally feasible, the substituents on the methylene group of the methylenediphenyl group can be bonded to each other to form one or more rings. The diphenyl groups of the methylene diphenyl group may also be joined together to form a ring. Some examples of methylenediphenyl groups are

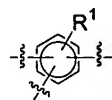


Referring to structure (I), Y is a single bond or a linker group. The linker group can be any chemical group that can withstand the polymerization conditions and allows the monomer to undergo nucleophilic, phenolic aromatic substitutions on the phenyl rings bonded to Y. Preferably, Y is a single bond and R^1 is F at each position on the phenyl rings bonded to Y. In some embodiments, Y comprises a single bond, an alkene or an alkyne group. In other embodiments, Y comprises a ketone, a sulfone, or a phosphine oxide group. The ketone, sulfone, or phosphine oxide group may be part of a linear chemical group or part of a ring that is

conjugated to the phenyl rings bonded to Y. Preferably, the ketone, sulfone, or phosphine oxide group is bonded directly to the phenyl rings bonded to Y, *i.e.*, Y is preferably



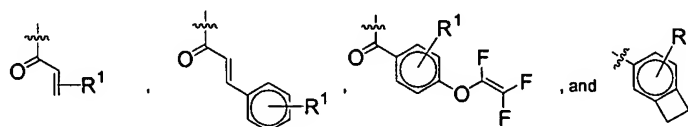
Referring again to structure (I), Q^2 may be a 6-membered aromatic or heteroaromatic ring, a polycyclic aromatic ring system, or a polycyclic heteroaromatic ring system provided that the ring or ring system is capable of forming a bond with both X^2 atoms and the Z linker group. Preferably, Q^2 comprises a phenyl ring to which both X^2 oxygen atoms are bonded, *i.e.* Q^2 comprises



When Q^2 comprises a phenyl ring to which both X^2 oxygen atoms are bonded, the oxygen atoms may be substituted *para*, *meta*, or *ortho* to each other. The linker group Z may be bonded to any atom in the ring and may further comprise heteroatoms, heteroalkyl groups, aryl groups, or heteroaryl groups. In many embodiments, linker group Z is $\text{--(CH}_2\text{)}_n\text{--}$ or $\text{--(OCH}_2\text{CH}_2\text{)}_n\text{--}$ having $n = 1$ to 10.

In some embodiments, R^3 is a crosslinkable group. In general, crosslinkable groups comprise functional groups that react to form bonds under certain conditions. The crosslinkable group may react with crosslinkable groups on another polymer chain or with additives (*e.g.*, diepoxides, diisocyanates, diisothiocyanates, and the like). The crosslinkable group may be chosen from any crosslinkable groups that are activated chemically, thermally, or photochemically. Photochemical activation may be through either a photoradical or photoacid. An alcohol of the polymer (*e.g.*, $\text{R}^3 = \text{H}$) may serve as a crosslinking group. The crosslinkable group may be attached to the monomer before polymerization, provided that no undesirable reaction occurs with the crosslinker during polymerization. The crosslinker may also be grafted onto polymer by any reaction between a functional group on the polymer and the crosslinker. Examples of such reactions are nucleophilic substitution or addition, etherification, or esterification with an alcohol on the polymer (*e.g.*, $\text{R}^3 = \text{H}$). For example, the crosslinkable group may be functionalized with a carboxylic acid that may be grafted onto the polymer using a chemical reagent that converts the

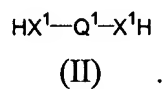
acid into an acylating agent *in situ*. Examples of such reagents are dicyclohexylcarbodiimide/dimethylaminopyridine (DCC/DMAP), a 2-chloropyridinium ion, and the like (see Carey and Sundberg *Advanced Organic Chemistry Part B: Reactions and Synthesis, Third Edition*, Plenum Press, New York, p 145-151 and others). Alternatively, the crosslinkable group may be functionalized with a carboxylic acid chloride, which can react with the alcohol polymer with the assistance of a base such as pyridine. Crosslinkable groups functionalized with a phenol may be grafted onto the polymer by the Mitsunobu reaction. Functional groups on the polymer may also be converted into other functional groups that can function as a site for grafting crosslinkers onto the polymer. The resulting functional groups may also be used as crosslinkable groups themselves. One such example is conversion of an alcohol on the polymer (*e.g.*, when $R^3 = H$) to an ester/acid by reaction with a cyclic anhydride such as succinic anhydride, phthalic anhydride, and the like. The carboxylic acid can be used to attach crosslinkers or can be used as a crosslinker itself by using additives such as diepoxides and the like. For examples, see U.S. Pat. No. 5,776,378; 4,859,758; and 4,539,340. Preferably, the crosslinkable group is one that can be crosslinked by methods known in the art, such as: a) by photoradical generators such as 1-hydroxycyclohexylphenyl ketone, acetophenon dimethylketal or benzoylmethyl ether and the like; b) by direct UV dimerization such as coumarins (US Pat. No. 6,423,818 B1) or cinnamates (US Pat. No. 5,484,821); and c) by thermal reactions such as with aryl trifluorovinyl ethers and benzocyclobutenes. Examples of such crosslinkable groups are



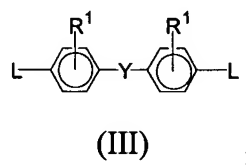
In one embodiment, Q^1 comprises a methylenediphenyl group in which the methylene carbon is bonded to at least two phenyl groups; Q^2 comprises a phenyl ring to which both X^2 oxygen atoms are bonded; Y is a single bond; and Z is $-CH_2-$. In this embodiment, R^1 at each occurrence on the phenyl ring bonded to Y is preferably fluorine. In another preferred embodiment, R^3 comprises an aryl trifluorovinyl ether. In another embodiment, the methylene of Q^1 is substituted with at least three phenyl groups.

In general, referring to Figure 1, polymers comprising units having formula (I) can be prepared by reacting about 1 equivalent of a compound 1 having at least two nucleophilic aromatic leaving substituents (L) with about 0.5 equivalents of a diphenol 2 and about 0.5

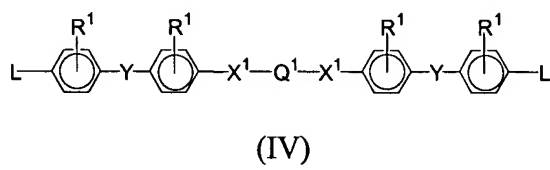
equivalents of a diphenol functionalized with an aliphatic alcohol **3**. A nucleophilic aromatic leaving substituent is a moiety that can act as a leaving group in an aromatic substitution reaction. A nucleophilic aromatic leaving substituent can be a single atom or a group of atoms, for example see F. A. Carey and R. J. Sundberg *Advanced Organic Chemistry, Part A*, 3rd ed. 1990, pp 579-583. If one of the diphenol compounds **2** or **3** is more reactive, the resulting polymer may have blocks resulting from reaction of **1** with the more reactive diphenol to give an oligomer, followed by reaction with the less reactive diphenol to give a block copolymer. Some applications, such as low loss optical polymers, may favor a copolymer without blocks (*i.e.*, a polymer that has substantially the structure in (I) throughout the polymer chain). The inventors have found that blockiness resulting from reactivity differences in the monomers can be overcome by a) reacting diphenol monomer A with monomer B to give monomer C with structure B-A-B, wherein monomer B has at least two sites for reacting with monomer A, and b) reacting diphenol monomer C with another monomer D to give a polymer. Referring to Figure 2, monomer A is



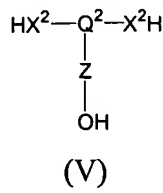
monomer B is



monomer C is

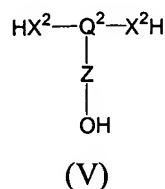


and monomer D is

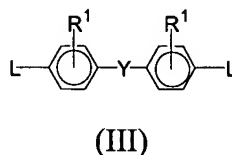


wherein Q¹, Q², X¹, X², Z, Y, R¹, and R² are as described above and L is a nucleophilic aromatic leaving substituent. Preferably, referring to structure (II), Q¹ comprises a

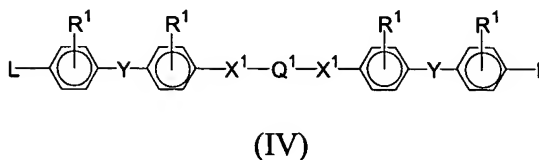
methylenediphenyl group, e.g., (II) is a bisphenol. L may be a halogen, nitro group, or phenylsulfonyl group. Preferably, L is fluorine. In one embodiment, reacting monomer A with monomer B comprises heating a mixture of monomer A and monomer B in a dipolar aprotic solvent to at least 110 °C. Dipolar aprotic solvents are known in the art and include dimethylformamide (DMF) and dimethylacetamide (DMAC). Another embodiment of the process further comprises cooling the reaction mixture of monomer A and monomer B after monomer C is formed and before monomer D is reacted with monomer C. Preferably, reacting monomer C with monomer D to form a polymer comprises heating a mixture of monomer C and monomer D in a dipolar aprotic solvent to at least 110 °C, thereby providing a polymer solution. In one useful embodiment, the process further comprises filtering the polymer solution while the temperature of the polymer solution is greater than about 80 °C. Such filtering removes most of the inorganic salts while ensuring the solubility of the polymer in the filtrate. In another embodiment, monomer A is



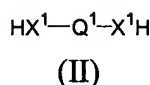
monomer B is



monomer C is



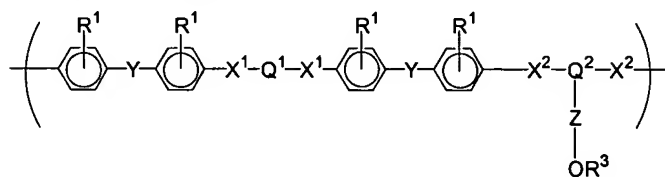
and monomer D is



wherein Q¹, Q², X¹, X², Z, Y, L, R¹, and R² are as described above.

The compositions made from the crosslinkable polyarylene ethers described above may be useful in variety of applications including low k dielectrics and passive optical components.

Another embodiment is a composition made by a process comprising a) providing precursor composition comprising a polymer having units with the formula (I)

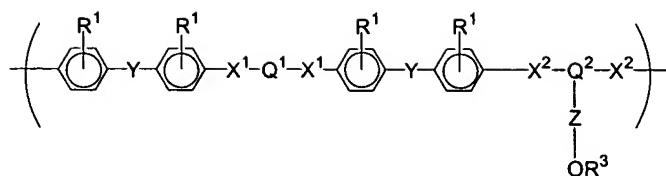


(I)

and b) crosslinking the polymer, wherein Q^1 , Q^2 , X^1 , X^2 , Z , Y , R^1 , R^2 , and R^3 are as described above. The precursor composition may be provided by known methods including spin coating, dip coating, brushing, printing (e.g., ink jet printing), and the like. Crosslinking may be accomplished by reaction of an R^3 crosslinking group with another R^3 crosslinking group or with additives that react with the R^3 groups. When R^3 is H, additives that react with alcohols can effect crosslinking (for example, diepoxides, diisocyanates, or diisothiocyanates). The crosslinking may be initiated thermally, chemically, or photochemically (e.g., by actinic radiation). The actinic radiation may crosslink two R^3 groups directly by dimerization or may produce a photoacid or photoradical crosslinking catalyst, for example see U.S. Pat. 6,555,288 and 6,020,508. Preferably, crosslinking the polymer comprises heating to at least about 200 °C.

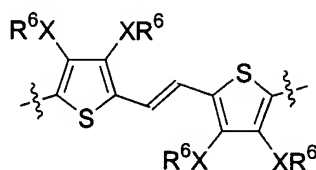
The fabrication of devices comprising optical waveguides including polymers is well documented, for example see U.S. Pat. 6,306,563. A typical optical waveguide comprises clad layers surrounding a waveguiding core. The refractive index of the clad layers is lower than the refractive index of the core. The crosslinked compositions described above have low optical loss and are useful for fabricating waveguide optical devices with enhanced performance. Another embodiment is a device including a waveguide comprising the crosslinked compositions described above. The crosslinked compositions may be used as the clad and/or the core. Preferably, the waveguide core and at least one clad comprise the crosslinked compositions.

Another embodiment is a composition made by a process comprising a) providing a precursor composition comprising a nonlinear optical chromophore having the structure D- π -A and polymer of structure (I)

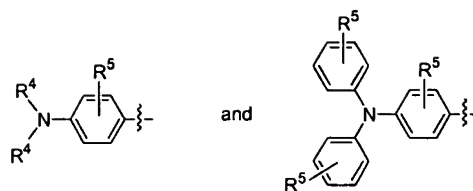


(I)

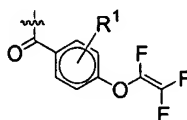
and b) crosslinking the polymer, wherein: D is a donor, π is a p-bridge, A is an acceptor, and Q^1 , Q^2 , X^1 , X^2 , Z, Y, R^1 , R^2 , and R^3 are as described above. The precursor composition may be provided by known methods including spin coating, dip coating, brushing, printing (e.g., ink jet printing), and the like. Preferably, the process further comprises applying an electric field to effect poling. Poling induces electro-optic activity in the polymer. The electric field may be applied using contact poling or corona poling. The poling may begin before crosslinking, during crosslinking, or after crosslinking, for example see co-pending, commonly assigned U.S. Pat. Appl. No. 10/301,978. The donor moiety D can comprise any of the structures shown in Figure 3, wherein independently at each occurrence: R^4 is H, an alkyl, an aryl, a heteroalkyl group, or a heteroaryl group; R^5 is H, a halogen except when bonded to a carbon alpha to or directly to a nitrogen, O, S, an alkyl group, an aryl group, a heteroalkyl group, or a heteroaryl group; Y is O, S or Se; m is 2, 3 or 4; p is 0, 1 or 2; and q is 0 or 1. Acceptor moiety A can comprise any of the structures shown in Figure 4, wherein independently at each occurrence, R^5 is H, a halogen except when bonded to a carbon alpha to or directly to a nitrogen, O, S, an alkyl group, an aryl group, a heteroalkyl group, or a heteroaryl group and Y is O, S or Se. In some embodiments, π comprises a thiophene ring having oxygen atoms bonded directly to the 3 and 4 positions of the thiophene ring. Preferably, the oxygen atoms are independently substituted with an alkyl, heteroalkyl, aryl, or heteroaryl group. An example of a π -bridge comprising a thiophene ring having oxygen atoms bonded directly to the 3 and 4 positions of the thiophene ring is



wherein, independently at each occurrence, X is O or S and R^6 is an alkyl, aryl, heteroalkyl, or heteroaryl group. Preferably, D is selected from the group consisting of



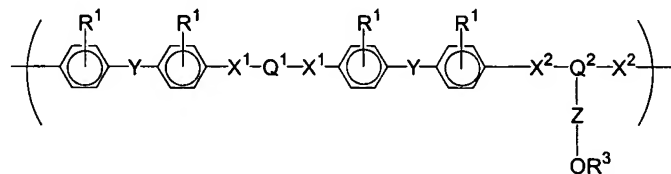
wherein, independently at each occurrence, R^4 is H, an alkyl group, an aryl group, a heteroalkyl group, or a heteroaryl group and R^5 is H, a halogen except when bonded to a carbon alpha to or directly to a nitrogen, O, S, an alkyl group, an aryl group, a heteroalkyl group, or a heteroaryl group. Preferably, each X is O and each R^6 is an alkyl group. In another preferred embodiment, R^3 comprises a fluorinated crosslinking group and at least one of R^4 or R^5 comprises a fluorinated crosslinking group. An example of a suitable fluorinated crosslinking group is



When the crosslinked compositions described above are electro-optic, electro-optic polymer devices comprising the compositions have enhanced properties over conventional electro-optic polymer devices due to an increase in thermal stability from the crosslinking. Thus, another embodiment is an electro-optic device comprising the crosslinked composition described above. The electro-optic device may be an optical modulator, an optical switch, or an optical directional coupler. Preferably, the electro-optic device comprises: 1) an input waveguide; 2) an output waveguide; 3) a first leg having a first end and a second end, the first leg being coupled to the input waveguide at the first end and to the output waveguide at the second end; and 4) a second leg having a first end and a second end, the second leg being coupled to the input waveguide at the first end and to the output waveguide at the second end. Another embodiment is an electro-optic device comprising: 1) an input; 2) an output; 3) a first waveguide extending between the input and output; and 4) a second waveguide aligned to the first waveguide and positioned for evanescent coupling to the first waveguide. Many telecommunication systems can be manufactured from the electro-optic devices described above. The systems can include optical routers and phased array radars. Other embodiments include a method of data transmission comprising transmitting light through the electro-optic composition described above, a method of telecommunication comprising transmitting light through the electro-optic

composition described above, a method of transmitting light comprising directing light through or via the electro-optic composition described above, and a method of routing light through an optical system comprising transmitting light through or via the electro-optic composition described above.

Another embodiment is a process comprising a) providing a polymer blend comprising two polymers, wherein at least one polymer is crosslinkable and at least one polymer is luminescent and b) crosslinking the crosslinkable polymer. Both polymers may be crosslinkable. Crosslinkable luminescent polymers are known, for examples see U.S. Pat. 5,708,130 and Muller, C. D., *et al. Nature* **2003**, 421 (6925), 829-833. The blend comprising two polymers may be provided by methods including dissolving the two polymers to make a solution and then depositing them by methods known to those skilled in the art like spin-coating, dip-coating, brushing, or printing (*e.g.*, ink-jet printing). In many embodiments, the luminescent polymer comprises a polyfluorene, a polyphenylenevinylene, or a polybiphenyl. Preferably, the luminescent polymer further comprises a charge transporter. The charge transporter may be a hole transporter or an electron transporter. The luminescent polymer may also contain both a hole transporter and an electron transporter. Some exemplary charge transporters are triarylamines, carbazoles, a 2,3-diphenylquinoxalines, and 1,3,4-oxadiazoles. Preferably, the crosslinkable polymer comprises the structure

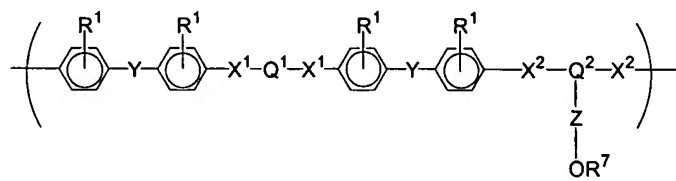


wherein Q¹, Q², X¹, X², Z, Y, R¹, R² and R³ are as described above. Preferably, R³ comprises an aryl trifluorovinyl ether. In many embodiments, the crosslinking is effected thermally, chemically, or photochemically.

Another embodiment is a luminescent composition comprising a polymer blend including a luminescent polymer and a second polymer, wherein at least one polymer is crosslinked. Preferably, the second polymer is crosslinked. In other embodiments, the luminescent polymer is crosslinked or both the luminescent polymer and the second polymer are crosslinked. The luminescent polymer may comprise a polyfluorene, a poly(phenylenevinylene), or a polybiphenyl. Preferably, the polymer that is luminescent further comprises a charge transporter.

Examples of charge transporters are triaryl amines, a carbazoles, a 2,3-diphenylquinoxalines, a 1,3,4-oxadiazoles.

In many embodiments, the crosslinked polymer comprises units having the formula



wherein Q^1 ; Q^2 ; X^1 ; X^2 ; Z ; Y ; R^1 ; and R^2 are as defined above and R^7 comprises crosslinked group. The crosslinked group R^7 is derived from a crosslinking group that has been crosslinked. R^7 may be derived from an acrylate, a cinnamate, an aryl trifluorovinyl ether, or a benzocyclobutene. Preferably, R^7 is derived from an aryl trifluorovinyl ether. Another embodiment is a device comprising a light emitting element, wherein the light emitting element comprises the luminescent composition described above. The light-emitting element may further comprise a charge injection layer. Charge injection layers typically have energy levels that are between the relevant energy levels of a reference electrode and a luminescent polymer. Preferably, the light emitting element further comprises a hole injection layer. Hole injection layers may comprise poly(3,4-ethylenedioxythiophene), poly(N-vinylcarbazole), polyaniline, or N,N'-diphenyl-N,N'-bis(3-methylphenyl)1,1'-biphenyl-4,4'-diamine. In other embodiments, the light emitting element further comprises an electron injection layer. Electron injection layers may comprise an oxadiazole, a benzobisazole, or a quinoxaline.

The luminescent compositions described above are useful, when crosslinked, in light emitting diodes and provide advantages over noncrosslinked light emitting polymer blends. To fabricate the light emitting diode, a light emitting polymer and a crosslinkable polymer, as described above, can be mixed to the desired ratio in a desired solvent. The solution may be spin coated on a substrate, which usually comprises an electrode. The solvent is evaporated and the films are crosslinked. Other polymers or metal electrodes can be deposited on the crosslinked films. Devices comprising the composition described above show enhanced performance over typical polymer light emitting diodes. Thus, another embodiment is a device comprising a light emitting element, wherein the light emitting element comprises the polymer blend described above. The light emitting element may further comprises a hole injection layer. Exemplary hole injection layers include those comprising poly(3,4-ethylenedioxythiophene), poly(N-vinylcarbazole), polyaniline, or N,N'-diphenyl-N,N'-bis(3-methylphenyl)1,1'-biphenyl-4,4'-

diamine. In other embodiments, the light emitting element further comprises an electron injection layer. Exemplary electron injection layers include those that comprise an oxadiazole, a benzobisazole, or a quinoxaline.

5 **Examples**

The following example(s) is illustrative and does not limit the Claims.

Example 1

Referring to Figure 5, Decafluorobiphenyl (100g, 0.3 mole), 4,4'-(1-phenylethylidene)bisphenol (43.55g, 0.15 mole) and 26g of K_2CO_3 were added to a 1 L round
10 bottom flask, followed by 400 mL of N,N-dimethylacetamide (99.9%, anhydrous). The bath temperature was ramped from room temperature to 120°C in 1 hour. The reaction was stirred at 120°C for 20 h. The temperature was cooled to 105 °C over 1 h to provide **10**, at which point 3,5-dihydroxybenzylalcohol (21.02 g, 0.15 mole) was added along with 20g of K_2CO_3 . Over the
15 course of 3 h, the bath temperature was ramped up to 115 °C and the flask contents allowed to react for one additional hour at 115 °C. The reaction mixture was then removed from the heat and filtered through a frit while still hot. 50 mL of THF was used to wash remaining polymer through the frit. The solution was cooled to room temperature, and transferred to a dropping funnel. The solution was added dropwise to a mixture of 750mL methanol-200mL DI H_2O in a
20 blender. The solid was collected on a frit, and dried in the air overnight. The solid was then taken up in 250mL of THF, forming a viscous solution. It was transferred to a dropping funnel and added dropwise to a solution of 500ml methanol-200ml DI H_2O . The solid was collected and air-dried on the frit for at least 5 hours. The solid was then heated at 80°C at 87 torr on a rotary evaporator for 5 hours. The product **11**, a fine white powder, was isolated in 30% yield
25 (114g).

Referring to Figure 5, 350 mL of anhydrous N-methylpyrrolidone was transferred into a 1 L one neck round bottom flask containing **11** (44.3g). Drisolv grade pyridine (100mL) was added. The mixture was stirred at room temperature for one hour, then 20.0g (0.085 mole) of 4-trifluorovinyloxybenzoyl chloride, **12**, was added to the solution. The solution was stirred, under
30 a nitrogen purge, for 20h. The color of the solution changed from light yellow to brown. The reaction was dropped slowly into a solution of methanol (500ml) and deionized water (200ml) in

a blender. The precipitate was filtered on a glass fritted funnel (coarse). Under the given dilutions, there was a reasonable amount of emulsified polymer in the filtrate, showing some amount of fractionation. The collected solid was washed with methanol (~2L), which further removed some of the existing yellow color. The resulting solid was dried on the frit in air for 48h. The solid was then transferred to a 1 L beaker, and 250 mL of THF was added. Once the polymer dissolved (~30min), it was transferred to a dropping funnel. It was added dropwise to a solution of methanol (750mL) and water (200mL) in a blender. Solid was collected on the frit, washed with additional methanol (~2L) and air dried on the frit (with vacuum) for ~4h. The solid was again dissolved in 250 mL of THF, and dropped into 750mlMeOH/200ml DI water while stirring in a blender. The solid was collected and dried overnight. Finally, the solid was taken up in 250ml of THF and dropped into 700ml MeOH/250ml DI water. The solid was placed in a 1L round bottom flask, and placed on a rotary evaporator (60°C, 10 Torr) for 4 h to give 40.0g of **13** as a white powder.

Referring to Figure 6, decafluorobiphenyl (56.12 g, 0.168), 2,2'-bis(4-hydroxyphenyl) hexafluoropropane (28.25 g, 0.084 mole), and 3,5-dihydroxybenzylalcohol (11.77 g, 0.084 mole) were added to a 500 mL round bottom flask, followed by 250 mL of N,N-dimethylacetamide (99.9%, anhydrous). The mixture was stirred at room temperature for 45 min in so that all of the components were completely dissolved. Next, potassium carbonate (51.14 g, 0.37 mole) was added and the flask placed into a preset 50°C oil bath for 45 minutes. Afterwards, the flask was moved into a preset 100°C bath, while stirring and keeping the temperature constant for 65 min. The reaction mixture was then removed from the heat and filtered through a frit while still hot. The solution was cooled to room temperature, and transferred to a dropping funnel. The solution was added dropwise to a mixture of 400mL methanol-100mL DI H₂O in a blender. The solid was collected on a frit, and dried in the air overnight. The solid was taken up in 250mL of THF, forming a viscous solution. It was then transferred to a dropping funnel and added dropwise to a solution of 400ml methanol-100ml DI H₂O. The solid was collected and air-dried on the frit overnight. The solid was heated at 80°C at 80 torr on a rotary evaporator for 5 hours. The product **14**, a white powder, was isolated in 40% yield (42g).

Referring to Figure 6, 20 mL of anhydrous N-methylpyrrolidone was transferred into a 100 ml one-neck round bottom flask containing **14** (10 g). Drisolv grade pyridine (3 mL) was added. The mixture was stirred at room temperature for one hour at which point the entire solid

was dissolved. 8.0 ml of 4-trifluorovinyloxybenzoyl chloride, **12**, was added to the solution. The solution was stirred, under a nitrogen purge, for 43h. The color of the solution changed from light yellow to brown. The reaction mixture (viscous solution) was transferred to a dropping funnel. The solution was added dropwise to a solution of 75ml MeOH / 25ml H₂O. The solid was collected on a frit, and air-dried. The solid was taken up in 25ml of THF, and added dropwise to a solution of 75ml MeOH / 25ml H₂O. The product **15** was collected, and the precipitation was repeated one additional time, yielding 5.2g of solid.

Example 2

In this example, a film of polymer **13** was provided and crosslinked. A solution of about 30% by wt. of polymer **13** in cyclopentanone was filtered through a 0.2 µm nylon filter and spin coated on a 6-inch silicon wafer having a 15 µm SiO_x surface. The polymer was baked at 150 °C under N₂ to help remove the solvent. The thickness of the resulting film was 4.0 µm. The film was then heated at 220 °C for 30 min under N₂ and cooled to room temperature. The average optical loss of five measured points was 0.77 dB/cm. The film was resistant to a variety of solvents.

Example 3

In this example, a film of polymer **16** (Figure 7) was provided and crosslinked. Polymer **16** was prepared in a similar manner as polymer **13**, except bisphenol A was used in place of 4,4'-(1-phenylethylidene)bisphenol). A solution of about 30% by wt. of polymer **16** in cyclopentanone was filtered through a 0.2 µm nylon filter and spin coated on a 6-inch silicon wafer having a 15 µm SiO_x surface. The polymer was baked at 150 °C under N₂ to help remove the solvent. The thickness of the resulting film was 2.9 µm. The film was then heated at 220 °C for 30 min under N₂ and cooled to room temperature. The average optical loss of five measured points was 0.62 dB/cm. The film was resistant to a variety of solvents.

Example 4

In this example, a polymer film of a nonlinear optical D-π-A chromophore and polymer **13** was provided and poled. Compound **17** (Figure 7) was the nonlinear optical chromophore, and was prepared as described in copending, commonly assigned U.S. Pat. Appl. No. 10/301,978. A 30% by wt. solution of **17** and polymer **13** in cyclopentanone was spin coated on 2" glass wafers coated with indium tin oxide (ITO) (~30 % by wt. solution of total solids with respect to cyclopentanone; the chromophore was loaded at 15% by wt. with respect to the

polymer). The wafer was soft baked at 100 °C under N₂ to help remove the remaining solvent from the film. A corona voltage of 5 kV was applied to the film while it was heated to 220 °C over 10 min (t = 0). The film was maintained at 220 °C for 40 min while the voltage was increased to 5.5 kV, 6.5 kV, and 7.5 kV at t = 15 min, t = 23 min, and t = 30 min, respectively. At t = 40 the wafer was brought to room temperature over about 10 min under the 7.5 kV field. The r₃₃ of the film was 24 pm/V (measured at 1310 nm by the Teng-Man method).

Example 5

In this example, a composition comprising a light-emitting polymer (LEP) and a crosslinkable polymer is provided. The light-emitting polymer used was ADS111RE from American Dye Source (polymer **18**, Figure 7). A 3% total solids by wt. solution of polymer **18** and polymer **13** in cyclopentanone was spin coated on a 2" glass wafer covered with ITO (the ratio of polymer **18** to the polymer **13** was 50/50 (wt./wt.)). The film was heated at 150 °C, and then heated at 220 °C under N₂. The resulting crosslinked blend film thickness was 100nm and was solvent resistant. In order to complete the fabrication of the polymer light emitting diode (50/50 LEP Blend), an aluminum electrode was e-beam evaporated onto the polymer.

For the purpose of comparison, an light emitting device (100% LEP) was fabricated using only polymer **18**. The light-current-voltage (L-I-V) curves for the 50/50 LEP **Blend** device and 100% LEP device are plotted on the same scale in Figure 8. The aluminum electrode was biased as the electron source and the ITO acts as the hole source. A definite increase in luminance and current is observed for 50/50 LEP Blend device over the 100% LEP device for most of the operating range.

A number of embodiments of the invention have been described. Nevertheless, it will be understood that various modifications may be made without departing from the spirit and scope of the invention. Accordingly, other embodiments are within the scope of the following claims.